

Work Order ID 139813

139813

Page 1

Wednesday, December 09, 2015 10:04:04 A

Item ID: D4034-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Upper Rib Assembly
 Start Date: 12/9/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

4
4 (3x)

Approvals: Process Plan: MLS Date: DEC 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	C								

100 Weld per dwg A/R S.S. rod Batch: B132768 0.00

100

Large Fab Memo 0.02
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT9564
 2- Weld bushing in rib as per dwg

3x CC 15-12-11

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00
 Quality Control

3x DAS 43 9-89 DEC 14 2015

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00
 Quality Control

3x DAS 43 9-89 DEC 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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130	Identify as per dwg & Stock Location: <i>WJA</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

3x *CC 15-12-11*

ML5 *DEC 14 2015*

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, December 09, 2015 10:04:10 AM

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139813

Parent Item: D4034-043

D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 12/9/2015

Required Date: 12/9/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-7 Hoop		Manufactured	No			100	Each	3.0000	1	4			
										**	CL 15-12-10		
										Location WA004 137710 Loc Qty 3 3 Loc Code B138986			
D4021-9 Bushing		Manufactured	No			100	Each	173.0000	4	16			
										**	CL 15-12-10		
										Location WA004 120334 122601 138306 138965 139552 Loc Qty 173 2 4 16 101 50 Loc Code			
D4034-1 Rib		Manufactured	No			100	Each	6.0000	1	4			
										**	CL 15-12-10		
										Location WA004 139329 Loc Qty 6 6 Loc Code			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Required Date: 12/9/2015

Start Qty: 4.00

Required Qty: 4.00

✓ D4034-3

Manufactured No

100

Each

7.0000

1

4

D4034-3

CL 15-12-10

Rib

Location

Loc Qty

Loc Code

WA004

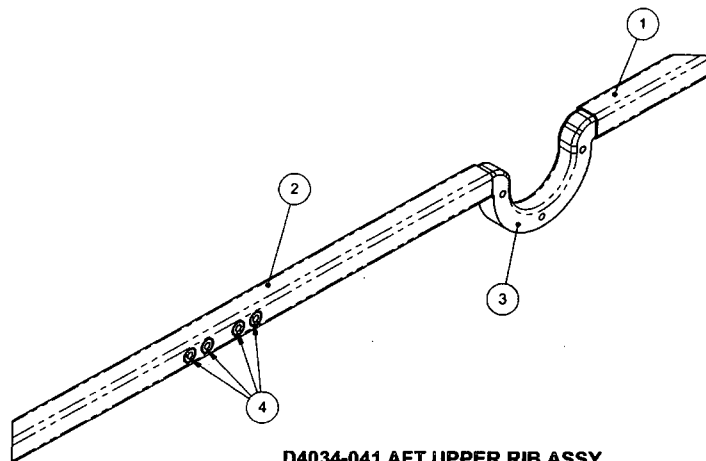
7

139364

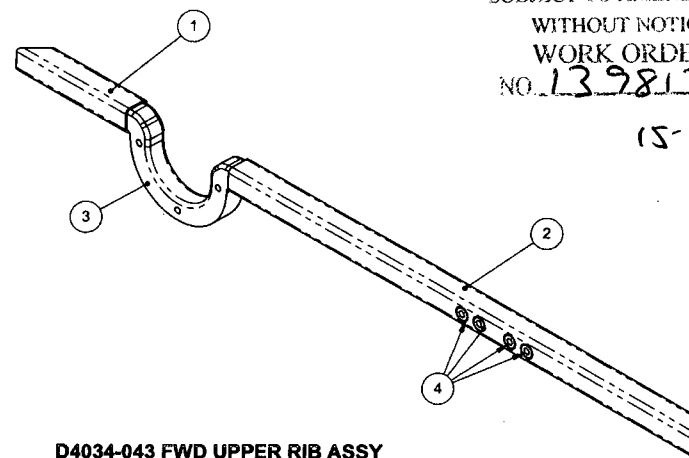
7

3x

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



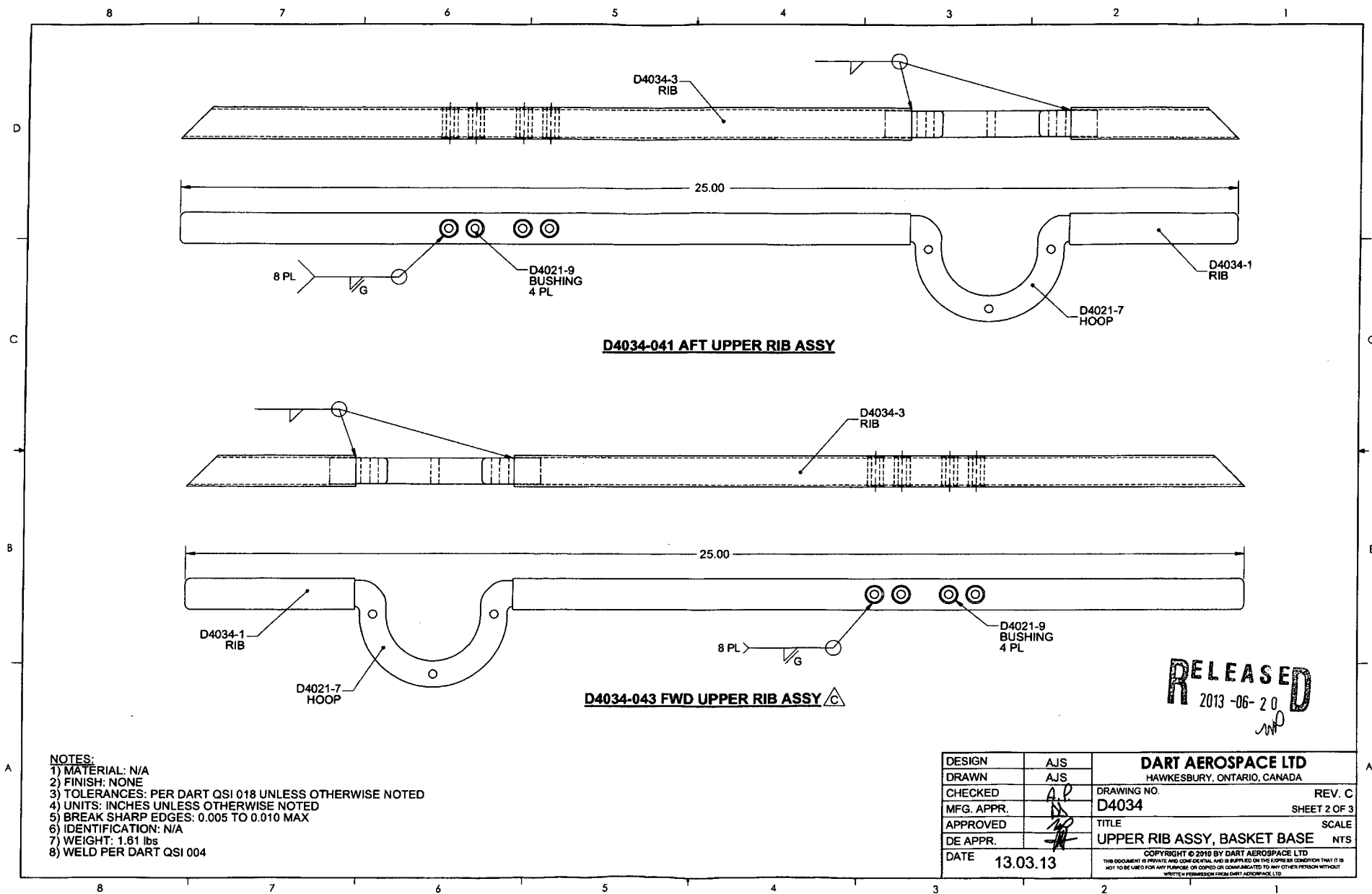
D4034-043 FWD UPPER RIB ASSY

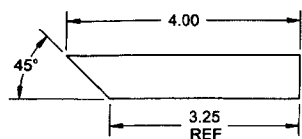
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15-12-09

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2013-06-20
AM

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4034 TITLE UPPER RIB ASSY, BASKET BASE SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS	REV. C SHEET 1 OF 3	
DATE	13.03.13		



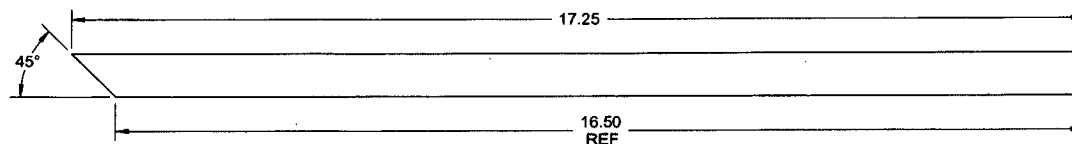
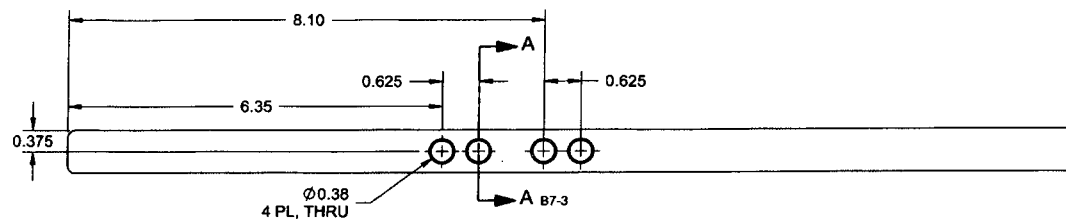
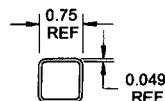


D4034-1 RIB

BREAK EDGE
0.030 X 45°
TYP



SECTION A-A C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. D4034	REV. C
MFG. APPR.	[Signature]	TITLE	SCALE
APPROVED	[Signature]	UPPER RIB ASSY, BASKET BASE	NTS
DE APPR.	[Signature]	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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